

# DuPont™ Excel™ Pro Topcoat

## 3.5 VOC (EZ quality)

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### Type

A two-component, 3.5 VOC, acrylic urethane topcoat.

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### Description

DuPont™ Excel™ Pro is ideal for manufacturers and refinishers who want a cost-effective finish that features good performance, good color capability and very good appearance. Available in solid and metallic colors, this topcoat uses the *DuPont Multi-Temperature Platform* for greater control over the application variables that affect cycle time and final appearance.

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### Suggested Uses

- Panel, multi-panel, overall applications
- Commercial vehicle bodies, trucks, trailers and other applications where good performance and appearance is required

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### Compatibility With Other Coatings

Compatible with all DuPont OEM and DuPont Commercial Finishes primer systems.

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### Not Recommended For

- Immersion Service
- Use over lacquer finishes

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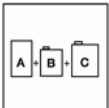
### Dry Film Characteristics

Chemical Resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity Resistance	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

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### Mix Ratio

Combine components and mix thoroughly. Filter material prior to spray application.



#### *Two Component System*

#### *Parts by Volume*

DuPont™ Excel™ Pro "EZ" Quality	4
DuPont™ 15303S™, 15305S™ or 15307S™ Activator	1

Add up to 2 oz. DuPont™ MasterTint® 389S™ Accelerator or 1 oz. DuPont™ MasterTint® 8989S™ Accelerator per activated gallon. Note: DuPont™ MasterTint® 8989S™ will shorten pot life.

Depending on color, the activated paint will have a viscosity of 10 – 20 seconds in a #3 Zahn cup.

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### Pot Life and Induction Time

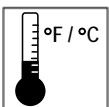
No induction time required. Pot life is 1-2 hours at 70°F (21°C); 2 hours at 70°F (21°C) with DuPont™ MasterTint® 389S™; 45 minutes at 70°F (21°C) with DuPont™ MasterTint® 8989S™



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### Application Conditions

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.



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### Additional Comments

- Heating activated material above 110°F (43°C) will cause gelation.
- When recoating DuPont™ Excel™ Pro with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.



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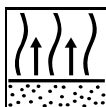
### Application

- Thoroughly mix DuPont™ Excel™ Pro prior to activation. The use of a cyclone paint shaker is recommended.
- Pressure pot application is recommended for best color match and all effect colors.
- Pressure pot fluid delivery should be set for 10 – 12 ounces per minute.
- Refer to spray equipment documentation for setting recommendations.
- Apply DuPont™ Excel Pro Topcoat (EZ quality) using a cross-coat technique. Spray a wet first coat using a top-to-bottom motion. Spray a medium-wet second coat using a side-to-side motion.
- Flash times between coats will vary between 30 seconds and 5 minutes. In general, the shorter the flash the smoother the appearance.
- Do not spray DuPont™ Excel™ Pro if the paint temperature is less than 75°F (24°C). Use warm water or paint heaters to heat the paint to an optimum temperature of 85-95°F (29-35°C).
- In case of fish eyes, add 1 oz DuPont™ 359S™ Paint Additive per ready to spray gallon of DuPont™ Excel™ Pro. Do not use FEE.
- To the activated gallon, add up to 2 oz. DuPont™ MasterTint® 389S™ or 1 oz. DuPont™ MasterTint® 8989S™.
- DuPont™ Excel™ Pro may also be force dried 30 minutes at 140°F (60°C).

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### Application Equipment

- Pressure Pot (recommended)
- Gravity Feed
- HVLP
- Air-Assisted Airless
- Airless



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### Cure Time At Recommended Thickness – 77°F (25°C) and 50% RH

	Without Accelerator	w/MasterTint® 389S™	w/MasterTint® 8989S™
Dry to Touch	3-5 hrs	0.5-1 hr	0.5-1 hr
Tack Free	6-8 hrs	2-3 hrs	1-2 hrs
Tape Free	10-12 hrs	3-5 hrs	1-2 hrs
Dry to Assemble	72 hrs	72 hrs	72 hrs

Product may be force dried 30 min between 120°F-140°F (48°C- 60°C) after a flash time of 15 min following application of final coat.

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### Point to Point Melt-In Guide - 70°F (25°C) AND 50% RH

Activator	Mixing Reducer	Flash Time
15303S™	15375S™ Low Temp Reducer	5-10 min
15305S™	15385S™ Mid Temp Reducer	15-20 min
15307S™	15395S™ High Temp Reducer	20-25 min

Depending on the surface area being coated, air temperature, and booth air flow, the above combinations of activators and mixing reducers should provide excellent overspray melt-in for the stated times.

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### Hot Weather Application

In addition to using the high temperature activator and reducers, add 15399S™ High Temp Additive up to 10% by volume to unactivated DuPont™ Excel™ Pro color and activate 4:1.

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### Maximum Service Temperature

200°F (92°C) in continuous service

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### Volume Solids

45% average unactivated  
49% RTS mixed 4:1 with DuPont™ Imron® 15305S™ Mid Temp Activator

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**Weight Solids**

59% average unactivated  
61% RTS mixed 4:1 with DuPont™ Imron® 15305S™ Mid Temp Activator

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**Weight Per Gallon**

9.2 lbs/gal average unactivated

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**Suggested Film Thickness**

1.8 – 2.2 mils dry film thickness

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**Theoretical Coverage Per Gallon**

780 sq. ft./gal @ 1 mil DFT

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**Gloss**

- High
  - DuPont™ PowerTint™ PT196™ Flattener Additive is available to obtain lower gloss if desired.
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**Color**

Solid and metallic colors

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**Flash Point (Closed Cup)**

Below 80°F (27°C)

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**Shelf Life**

12 months

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**Application Solvents**

Ready-to-spray VOC is below 3.5 lbs/gal VOC upon activation. Further reduction may result in greater than 3.5 VOC.

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**Cleanup Solvents**

DuPont 3602S™ Thinner  
DuPont 15385S™ Reducer  
DuPont TP33364™ Thinner

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**Environmental**

VOC content (lbs/gal)	LE	AP
DuPont™ Excel™ Pro "EZ"	3.8	3.6
RTS mixed 4:1 w/ DuPont™ Imron® 15305S™	3.5	3.3

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**For Voc Regulated Areas**

These directions refer to the use of products that may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

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**Safety And Handling**

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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